

Work Order ID 84813***84813***

Page 1

Wednesday, May 23, 2012 1:30:52 PM

Item ID: D3372-041

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Collective Lock Assembly

Start Date: 5/23/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/23/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *ME*Date: *12-05-23* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3372

Rev B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372
Identify as D3372-3

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

0.00

120

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and
lock barrel. Discard the rest.
2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as
D3369-5

UNALIKE

FF
12-05-23S
12-05-23FF
12-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84813

84813

Page 2

Wednesday, May 23, 2012 1:30:52 PM

Item ID: D3372-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Collective Lock Assembly

Stop ***NS2***

Start Date: 5/23/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/23/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Small Fab

0.00

Small Fab

Memo

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty	Part Number	Description	Batch
A/R	N/A	Locktite 262	120369

Identify as D3372-053

2-Assemble D3372-051 as per Dwg

①

FF
12-05-23

140

0.00

140

Large Fab

0.00

Large Fab

Memo

Tack weld lock shaft as per Dwg D3372

A/R	SS Rod	Batch
		M11450P

②

- R 12-5-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 84813

84813

Page 3

Wednesday, May 23, 2012 1:30:52 PM

Item ID: D3372-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Collective Lock Assembly
 Start Date: 5/23/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/23/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1x			Pd 12.05.23
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			WHL 12.05.23
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				SD			WHL

C413A

W/O:		WORK ORDER CHANGES					
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Page 4

Wednesday, May 23, 2012 1:30:52 PM

Item ID: D3372-041

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Revision ID:

Stop ***NS2***

Item Name: Collective Lock Assembly

Start Date: 5/23/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/23/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

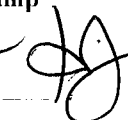
180

QC

Memo

0.00

Quality Control

12/5/25 
mf
12-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 23, 2012 1:30:51 PM

Page 1

Work Order ID: 84813

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 5/23/2012

Required Date: 5/23/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM
 IPP Rev:B Added Key ID _____ 06.03.21 EC
 10.05.13 verified :EC
 IPP Rev:C added D3384-043 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC SS Flat Washer 5/16 FW516SI		Purchased	No			100	Each	1,694.0000	2	2			FF 12-05-23
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	2					
				ST377	115072	1674							
					120262	1674							
				ST522		20							
					120208	20							
AN5-42A Bolt		Purchased	No			100	Each	30.0000	1	1			FF 12-05-23
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST340		30							
					108442	10				1			
					119438	10							
					119449	10							
AN960-416 Washer	NAS1149F0463P	Purchased	No			100	Each	0.0000	2	2			SB 12/05/23
D2728-7 Dart Logo label		Manufactured	No			100	Each	0.0000	0	0			FF 12-05-23
D3372-1 Main Body		Manufactured	No			100	Each	4.0000	1	1			FF 12-05-23
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST491		2							
					75202	2				1			
				ST492		2							
					75126	2							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, May 23, 2012 1:30:51 PM

Page 2

Work Order ID: 84813
Parent Item: D3372-041
Parent Item Name: Collective Lock Assembly

Start Date: 5/23/2012 Required Date: 5/23/2012
Start Qty: 1.00 Required Qty: 1.00

D3372-5 Manufactured No

100 Each 9.0000

1 1

Cam Lock Shaft

FF 12-05-23

Location Loc Qty Loc Code

ST038 9

79039 9

D3372-7 Manufactured No

100 Each 1.0000

1 1

Slider Body

FF 12-05-23

Location Loc Qty Loc Code

ST492 1

75203 1

D3373-1 Manufactured No

100 Each 43.0000

1 1

Cam Lock

FF 12-05-23

Location Loc Qty Loc Code

ST039 43

58463 2

74862 19

75666 22

D3384-043 Manufactured No

100 Each 1.0000

1 1

Cyclic Sock Assembly

FF 12-05-23

Location Loc Qty Loc Code

ST486 1

80273 1

HX-81 Purchased No

100 Each 83.0000

1 1

1/4"-20 SHCS 3/8" long

FF 12-05-23

Location Loc Qty Loc Code

ST 50

120357 50

ST390 33

114383 1

120773 32

Wednesday, May 23, 2012 1:30:51 PM

Shop Packet Print

Page 2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

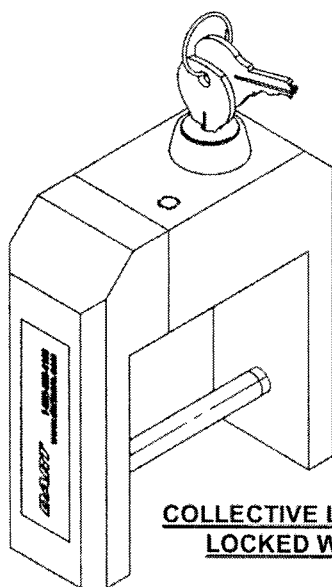
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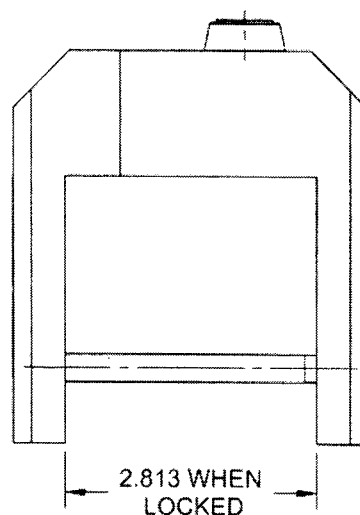


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	

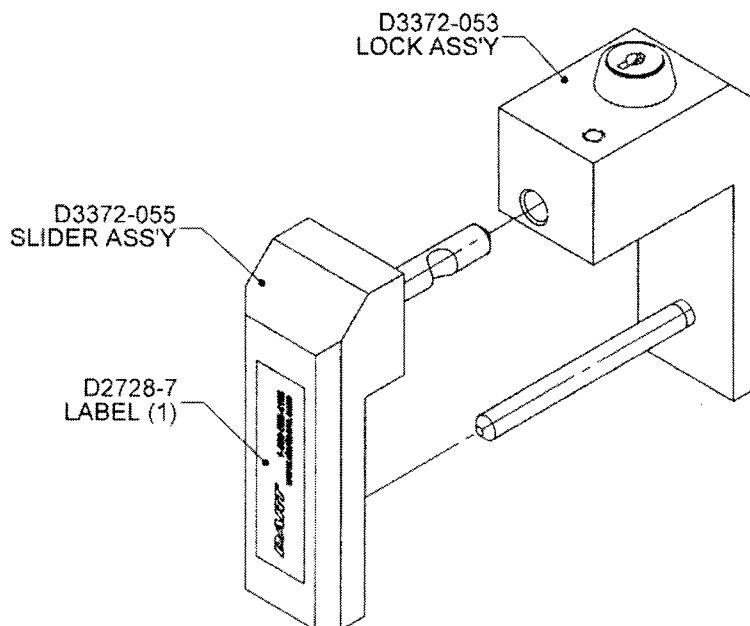


**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**

Elphs #



2.813 WHEN
LOCKED



RELEASED
[Signature]
05/04/23

D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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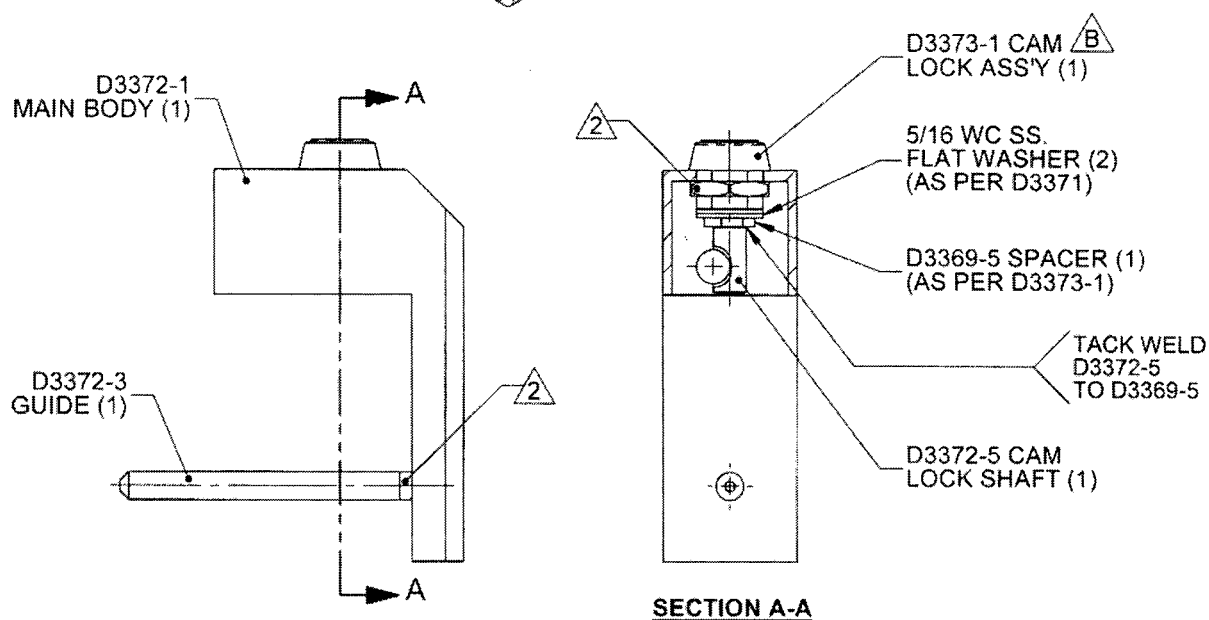
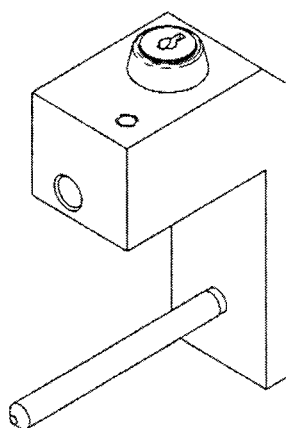
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 2 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

E 1828#

RELEASED
[Signature]
05/04/23



D3372-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

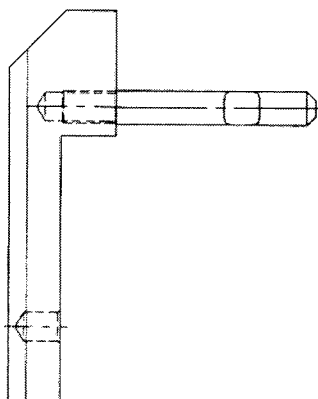
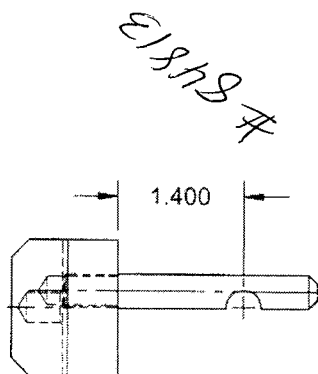
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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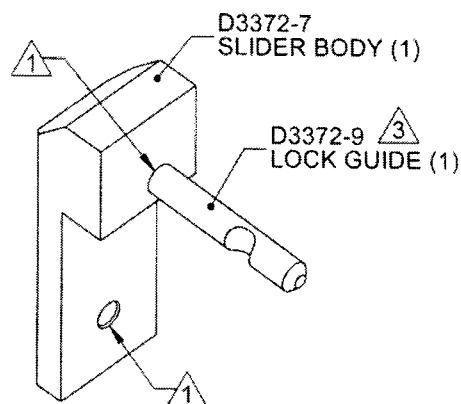
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 3 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



RELEASED
[Signature]
05/04/23



D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3372	REV. B
DATE 05.02.23		TITLE COLLECTIVE LOCK	SHEET 4 OF 8
			SCALE 1:2

05/04/23

RELEASED

2 DRILL $\phi 0.201 \times 0.600$ DEEP
TAP $1/4-20$ UNC $\times 0.400$ DEEP

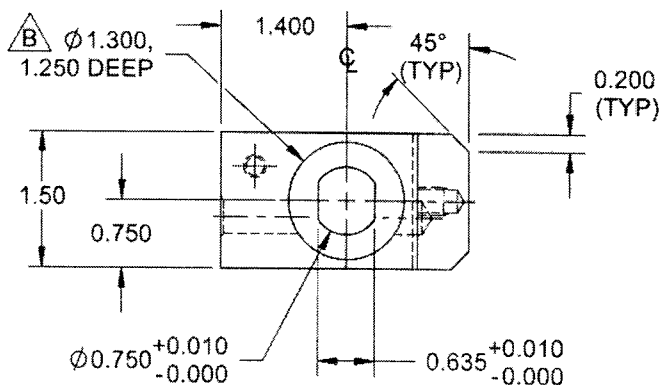
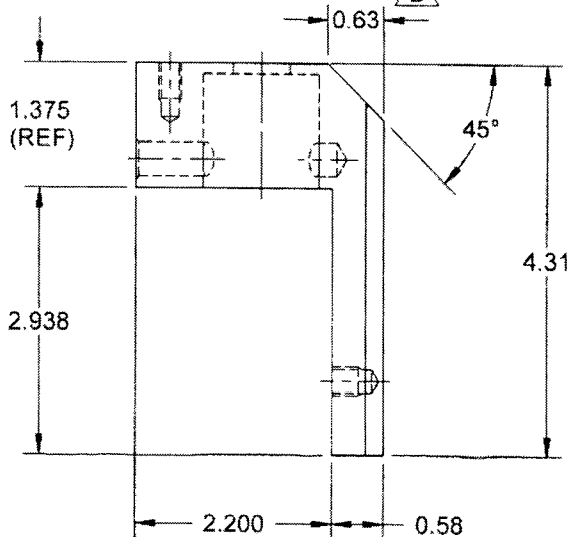
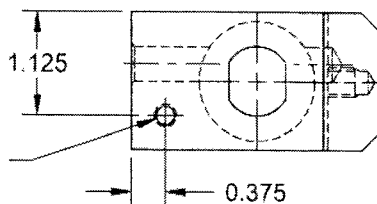
2 DRILL $\phi 0.377$,
2.363 DEEP.
CHAMFER $0.031 \times 45^\circ$

0.313

2.108

2 DRILL "I" DRILL
 $\times 0.525$ DEEP
THREAD $5/16-24$ UNF
 $\times 0.300$ DEEP

0.750



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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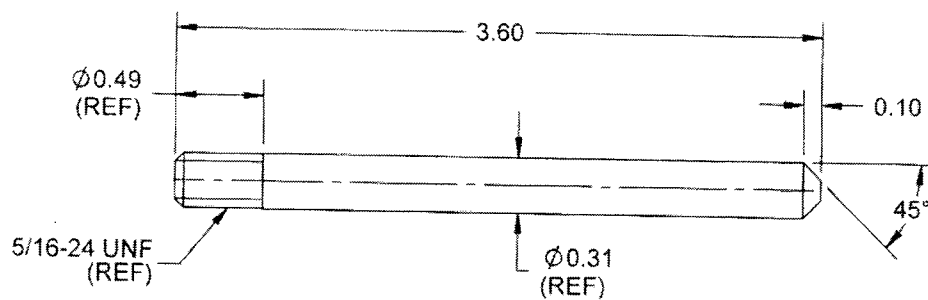


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 5 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

218188#

SPECIFICATION CONTROL DRAWING

RELEASED
[Signature]
05/04/23



D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

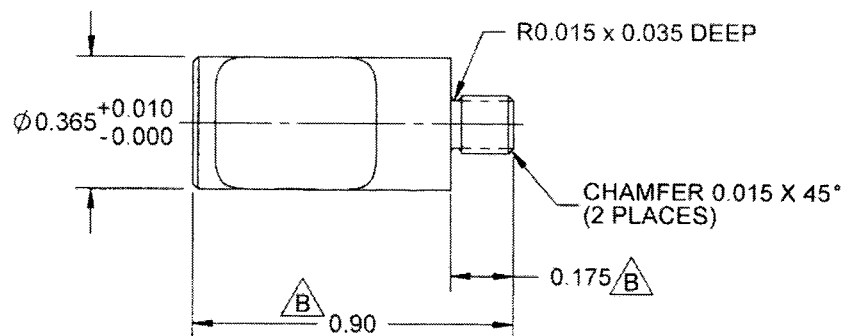
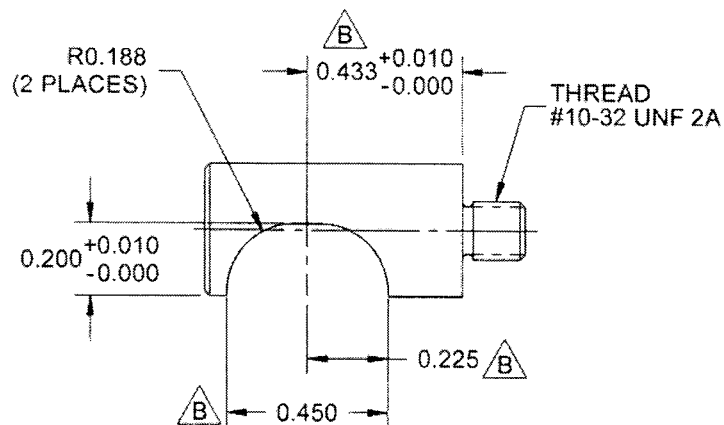
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 6 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

*E111-8**

RELEASED
[Signature]
05/04/28



D3372-5 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

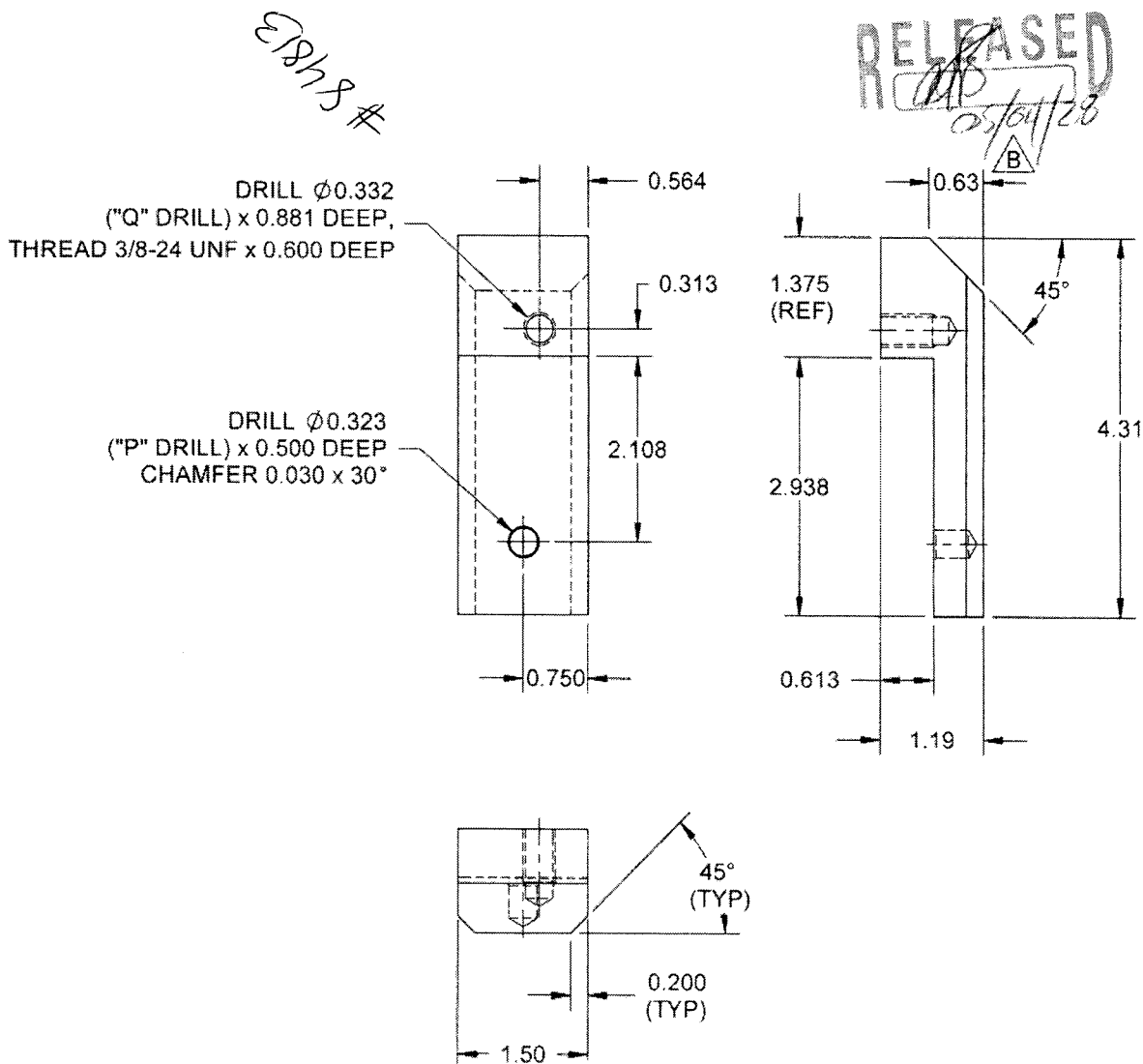
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 7 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

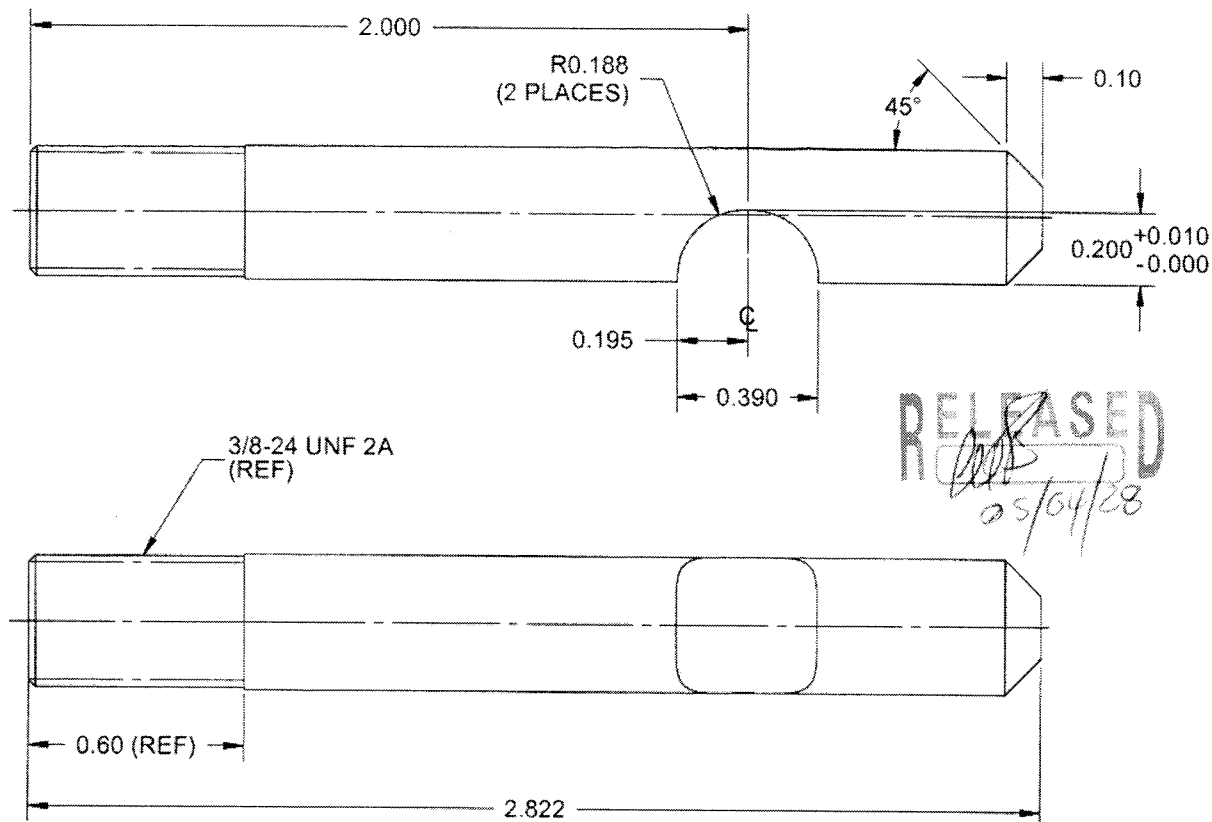
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 8 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

01848#

SPECIFICATION CONTROL DRAWING



D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries